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D3914-041
Job Sheet 201473



Part No: D3914-041

Job Qty: 1 pcs

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/4/19

Job Tracking No:

Due Date: 10/30/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	10/30/19		0.00	10.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		DAS
							Large Fab - 6		43
							Large Fab - 7		9-89
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
110	QC 9	1 pcs	10/30/19		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		DAS
							QC 9 - 43		24
							QC 9 - 50		9-89
							QC 9 - 9		
120	QC 5	1 pcs	10/30/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		DAS
							QC 5 - 24		24
							QC 5 - 3		9-89
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		



Container No: S220441



Part: D3914-041

Job No: 201473

Serial No/Batch: S220441

Revision: A/D

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/07/19

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						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
130	Powdercoat - 4 Black Sand - B4B	1 pcs	10/30/19	0.00	0.40	Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
135	QC 3	1 pcs	10/30/19	0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
140	Handfinish - 3-1-WingWalk-B4B	1 pcs	10/30/19	0.00	0.80	Handfinish - 3 - 1 - B4B	
						Handfinish - 3 - 2 - B4B	
						Handfinish - 3 - 3 - B4B	
						Handfinish - 3 - 4 - B4B	
						Handfinish - 3 - 5 - B4B	
150	QC 3	1 pcs	10/30/19	0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	

BR 19-10-10

BEB 19-10-11

BEB 19-10-11

ML 19-10-15

DAS
59
9-89AS
59
9-89

						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
						Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
160 Packaging 3-1 - Stock - B4B	1	10/30/19	0.00	0.00	pcs	Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	BEB 19-10-15
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 - B4B	
						Packaging 3 - 33 -	

					B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
170 QC 21 - SA	1	10/30/19	0.00	0.00	QC 21 - SA - 21	DAS
	pcs				QC 21 - SA - 70	OCT 16 2019 70
					QC 21 - SA - 53	9-89

Part Op 100 - (Weld per dwg A/R S.S. rod Batch: 4139022 - assemble ribs , weld as per dwg D3914 using DT9607A 2- weld
 Descriptions: hinge (3) and Mounting brackets as per dwg D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on
 basket as per dwg D3914 ***Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure
 to place mesh correctly on lid, check with label plate before tacking mesh***

110 - QC9- Inspect visual per QSI004- Fusion Welds

120 - QC5- Inspect part completeness to step on W/O

130 - Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 *** mask sides of hinge prior to powdercoat***

135 - QC3- Inspect Part Finish

140 - Wing Walk as per dwg QSI005 4.4 Batch 5209362 1- Mask data plate and apply wing walk on outside surface of
 mesh as per dwg 2- Install label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand
 area for label, apply label ***

150 - QC3- Inspect Part Finish

160 - Identify as per dwg & Stock Location:

170 - QC21- Final Inspection - Work Order Release

012283

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
✓ D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5211240
✓ D3914-1	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5219773
✓ D3914-7	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5214596
✓ D4016-3	Hinge Half, Lid	3 pcs (3 ea)	100-Large Fab - Basket - 1	DAS 5193147
✓ D4018-5	Rib	9 pcs (9 ea)	100-Large Fab - Basket - 1	43 5219055
✓ D4020-5	Mesh (350 Basket Long, Lid)	1 pcs (1 ea)	100-Large Fab - Basket - 1	9-89 5219012
✓ D4021-3	Data Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	5172801
✓ D4035-043	Lid Rib Assembly, Aft (350 Basket)	2 pcs (2 ea)	100-Large Fab - Basket - 1	5211317

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	121	0
	D3914-1	2	0	0
	D3914-7	2	10	0
	D4016-3	3	27	0
	D4018-5	9	98	0
	D4020-5	1	9	0
	D4021-3	1	15	0
	D4035-043	2	8	0

Part Specifications

Specifications could not be found.

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Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS		Route update only ☐																																	
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QS1042)																																	
Description Work Order Deviation		Disposition																																					
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY																																					
		Pressure/Forced Bending ☐		Crushing ☐		Cracks ☐		Crimp/Kink/Ripple/Wave/Twist ☐		Marks/Chatter ☐		Mislabeled ☐		Other/Details: _____																									
Contamination ☐		Misaligned/off center ☐		BOM/Route ☐		Broken/Damage/Defect ☐		Incomplete/Unclear Instructions ☐		Drill Holes ☐		Fit/Function ☐		Power Loss/Surge ☐		Folio/Program ☐		Grain Direction ☐		Weld ☐		Wrong Stock Pulled ☐		Out of Sequence ☐		Off-set/Set-up ☐		Positioned Wrong ☐		Outside Tolerance ☐		Drawing ☐		Finish ☐		Part Lost/Missing ☐		Misread ☐	
Completed By		Lead hand / Supervisor		QC / QA Coordinator																																			